

Date: Wednesday, 21/05/2008 11:30:10 AM
 User: Linda Lacelle

Process Sheet

FOR ENGINEERING USE ONLY

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : ANGLE-PROTO

Job Number : 05000

Estimate Number : 10804

P.O. Number :

Part Number : D37081 *PROTOTYPE 08.05.20*

This Issue : 21/05/2008 S.O. No. :

Drawing Number : D3708

Prsht Rev. : NC

Project Number :

First Issue : / / Type : R & D SM/MED FAB

Drawing Revision :

Previous Run : 00015

Material :

Due Date : 28/05/2008 Qty: 1 Um: Each

Written By : Checked & Approved By : 

Comment :

Additional Product

PROTOTYPE PRELIMINARY ISSUE

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 MAKE PER DRWG D3708 REV.A

08.05.21

2.0	M606116A750W0625	angle 750 x 750 x.1/16w
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*6063-75 ACCEPTABLE**M107711*

Comment: Qty.: 1.5000 f(s)/Unit Total : 1.5000 f(s)
 angle 750 x 750 x.1/16w

08.05.21

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING APPROVAL*08.05.21*

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
 ACID ETCH AND ALODINE

Not required

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Not required

6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 ENGINEERING -MARC

08.05.21

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Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE

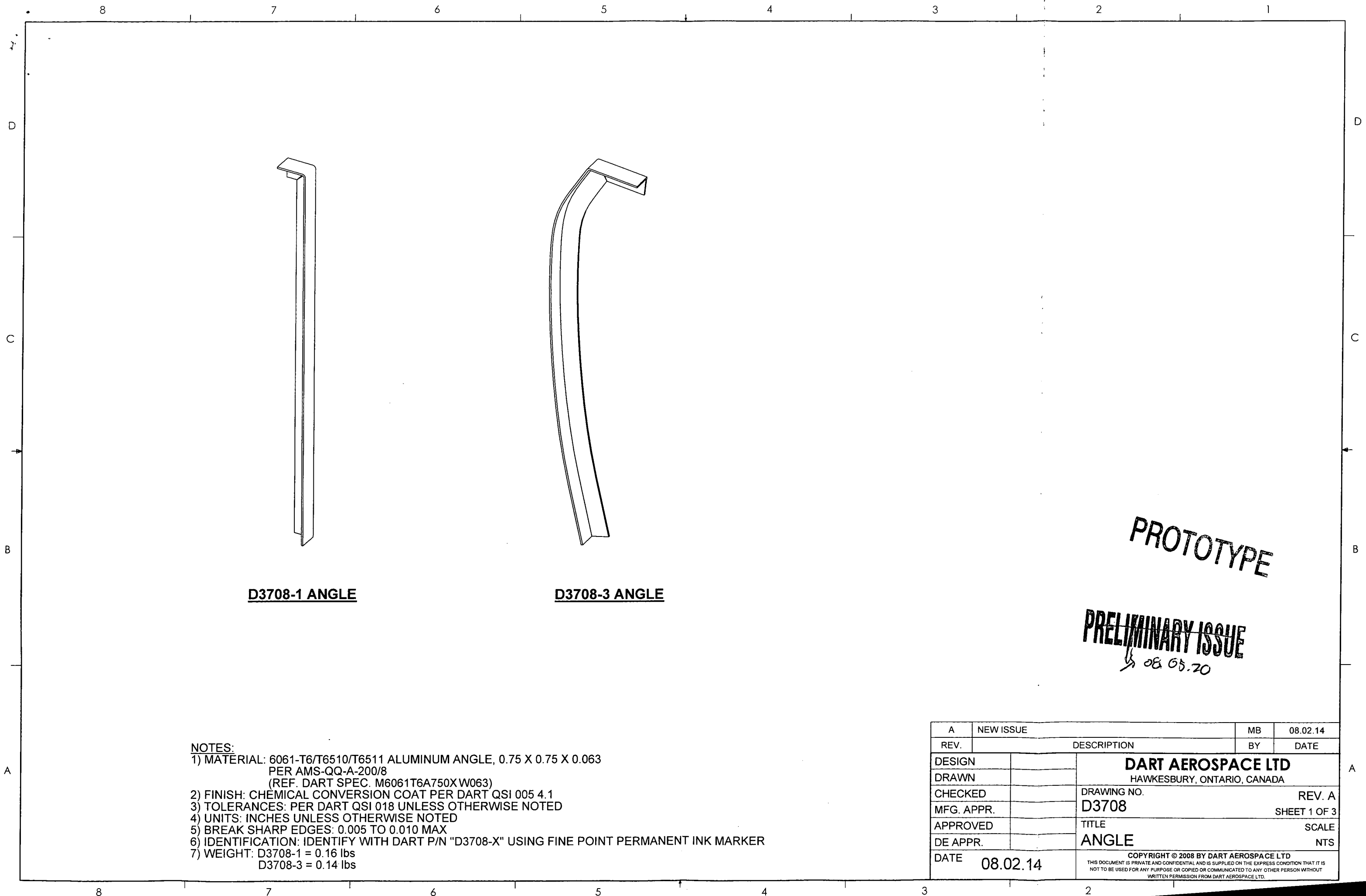


Comment: FINAL INSPECTION/W/O RELEASE

08.06.22 Prototype
MF 08-06-13

Job Completion





D3708-1 ANGLE

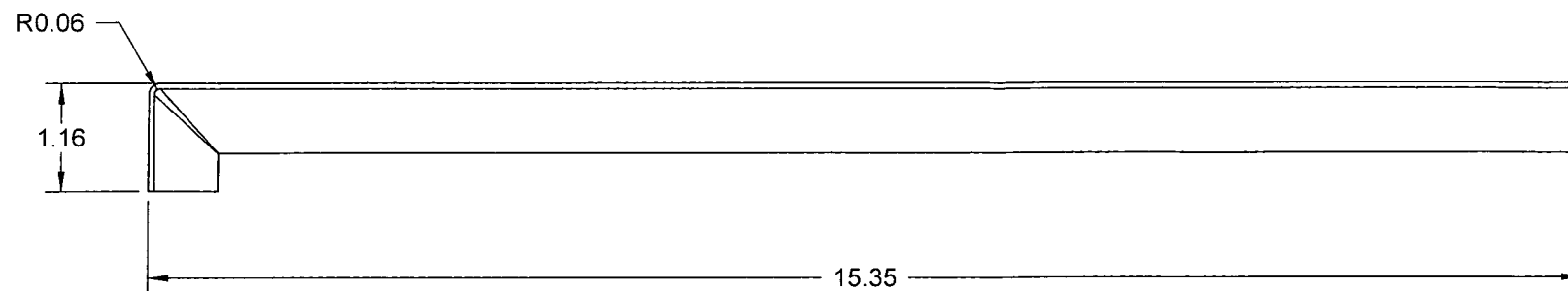
D3708-3 ANGLE

PROTOTYPE

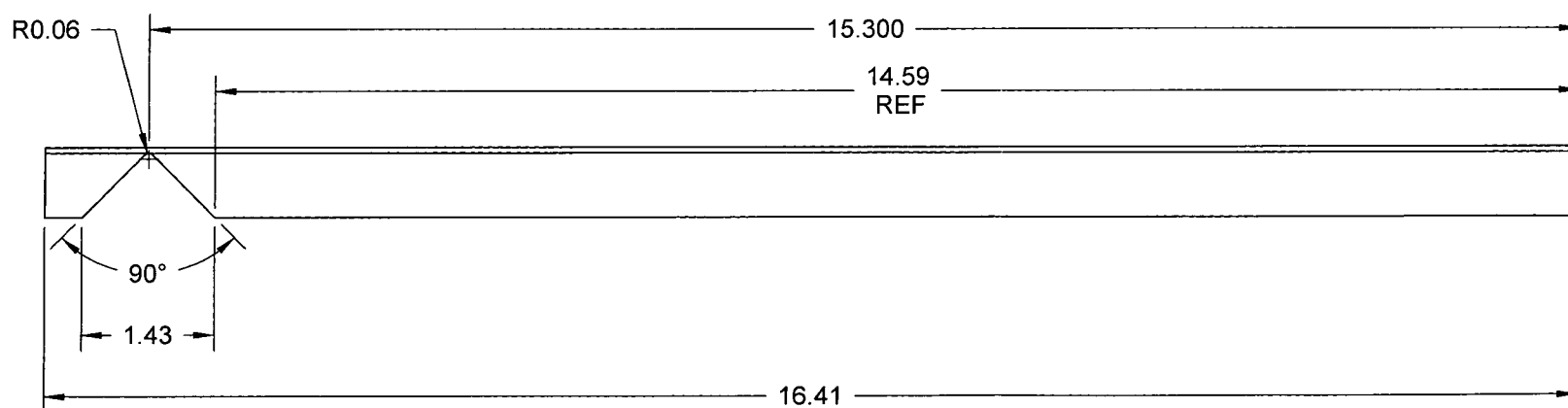
PRELIMINARY ISSUE
08.05.20

- NOTES:**
- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.063
PER AMS-QQ-A-200/8
(REF. DART SPEC. M6061T6A750XW063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3708-X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3708-1 = 0.16 lbs
D3708-3 = 0.14 lbs

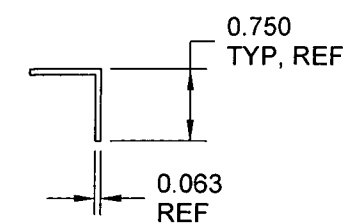
A	NEW ISSUE		MB	08.02.14
REV.	DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.		REV. A
MFG. APPR.		D3708		SHEET 1 OF 3
APPROVED		TITLE		SCALE
DE APPR.		ANGLE		NTS
DATE	08.02.14		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3708-1 ANGLE
(MAKE FROM D3708-1F)



D3708-1F FLAT PATTERN



PROTOTYPE

PRELIMINARY ISSUE

08.02.20

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3708	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ANGLE	NTS
DATE	08.02.14	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Receiving Report

Date: 8/4/11

Batch No: M107711

Supplier: Camp

Dart P/O: 6075

Packing Slip: ☒ Yes ☐ No
 Invoice: ☐ Yes ☐ No
 Receipt: ☐ Cash ☐ Cr

Release Note Attached: ☒ Yes ☐ No
 Waybill Attached: ☒ Yes ☐ No
 Shipment Complete: ☒ Yes ☐ No
 QC6 Inspection: ☒ Yes ☐ No
 Work Order: 6075

Discrepancies	Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
	M107711	30050	96	64	0	32	
	M107711	30050	120	0	0	12	
	M107711	30050	120	128	0	128	
	M107711	30050	120	126	0	126	

Initials of receiver (if shipment OK) Level 12
over 6
over 2
over 1

Production/Admin: 8/4/11
 Date: 8/4/11
 Received/Costing: BCP 7618 + 7674
 Initial: CS
over 6
over 2
over 1

H:\FORMS\Purchasing\approved purchase\REPORT Rev D

377-4248
377-5696

MONTREAL : 514 336-4248
FAX : 514 336-4246

DISTRIBUTEUR D'ACIER ET METAUX SPECIALISES
STEEL AND SPECIALTY METALS DISTRIBUTOR

ONTARIO : 1 800 667-4248
FAX : 1 866 456-4242

On a du Savoir "FER"

SHIP TO:

SPACE LTD
DEEN STREET
Y.

FACTURE INVOICE	N° 107915
DATE	11/04/08
BON DE LIVRAISON PACKING SLIP	N° 133557
DATE DE LIVRAISON DELIVERY DATE	11/04/08

TERMES / TERMS	TERR.	REMARQUES / REMARKS	PAGE N°
NET 30 JOURS	2R		001

DESCRIPTION	POIDS WEIGHT	PRIX PRICE	PAR PER *	MONTANT AMOUNT
050 4' X 12' ✓	2	585.790		1171.58
3/4	11	450.000	CLB	51.98
050 48 X 144 ✓	2	225.600		451.20
4 X 3/4 X 1/16	2	14.000		28.00
LARGE	1	3.950	UN	3.95
POIDS TOTAL	10			
TOTAL WEIGHT				

Formplus N° 8619

LS REMAIN THE PROPERTY OF "ACIER CAMP" INC. UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED. BUYER'S EXPENSE. • ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER. RESPECT THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY 12 MONTH OR 24% PER ANNUA ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. • ANY DEFAULT IN RESPECT WITH 12 MONTH OR 24% PER ANNUA ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. • ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. • ANY MERCHANDISE 1 MODIFIED CANNOT BE RETURNED. • ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE 30E.

BONNE CONDITION / MERCHANDISE RECEIVED IN GOOD CONDITION

A/Y M/M J/D

AGENT / CUSTOMER'S SIGNATURE:

DATE

SOUS-TOTAL	1706.71
SUB TOTAL	
T.P.S. G.S.T.	55.34
T.V.Q. Q.S.T.	2.20
TOTAL	1764.25

11100
03 OCT. 2007



LONGKOU NANSHAN ALUMINUM GENERAL FACTORY

NANSHAN INDUSTRY ZONE LONGKOU CITY SHANDONG

PROVINCE CHINA

TEST REPORTS

Order No.: A2897 Test Date: 2006.6.11
Description of Goods: Angle(Sq.Fillets) Alloy /Temper: 6063-T5
Standard For Test: ASTM B221-2004.AMS-QQ-A-200/9
Heat No.: 190 Net Weight(lbs): 1070
Bundle No.: 193-199 Size(inch): .750"x.750"x.065"x252"
Die No.: NSXC 109-004

TABLE OF RESULT DETAIL

A. CHEMICAL COMPOSITION

Angle Alum.
3/4 x 3/4 x 1/16

Test Items		Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Impurities	
Normal Requirements	Min	0.20	/	/	/	0.45	/	/	/	Each	Total
	Max	0.60	0.35	0.10	0.10	0.9	0.10	0.10	0.10	0.05	0.15
Test Results		0.45	0.11	/	/	0.55	/	/	/	0.05	0.15

B. MECHANICAL PROPERTY

Test Items	Ultimate Strength	Yield Strength	Elongation
Units	KSI(min)	KSI(min)	%(min)
Normal Requirements	22.0	16.0	8
Test Results	34.7	31.9	13

It is hereby certified that the above material is manufactured in compliance with the specified standards and meets the stipulated requirement.

Authorized Department: Quality Test Department

Inspector: 张亚飞

Quality Manager: Kexin Yao

Signature: 姚克欣

LONGKOU NANSHAN ALUMINUM

GENERAL FACTORY

